Qty:

Date

Thursday, 19/02/2009 1:59:37 PM

User:

Julie Dawson

: //

## **Process Sheet**

Customer : CU-DAR001 Dart Helicopters Services Job Number : 45915 **Estimate Number** : 10256 P.O. Number : 19/02/2009 This Issue : NC Prsht Rev.

S.O. No. :

: MACHINED PARTS Type : 45303

**Part Number Drawing Number** 

**Due Date** 

Project Number

**Drawing Name** 

: D22303 : D2230 REV F

: MOUNTING LUG

: N/A : F

**Drawing Revision** Material

: 26/02/2009

100 Um:

Each

Checked & Approved By

Comment

Added inspection level 8, and removed P/O for

EC powder coat

**Additional Product** 

First Issue

Written By

**Previous Run** 

Job Number:



Seq. #: 1.0 D2423

**Machine Or Operation:** 

**Description:** 

Lug Extrusion

Comment: Qty.:

Total: 0.0717 f(s)/Unit

7.1715 f(s)

Lug Extrusion

D2423

19. 8100 Batch:

2.0

D22303P

LUG



Comment: Qty.:

1.0000 Each(s)/Unit

Total: 100.0000 Each(s)

LUG

3.0

BAND SAW

Comment: Band Saw

Cut D2423 extrusion to 0.82"

Batch: 3 44529

HAAS1 4.0

HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio D2230-3

Check for crack while loading into the machine.

5.0

QC2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Dart	<b>Aeros</b>	pace	Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector

Part No:	PAR	#: Faul	Category:	NCR: Yes No	DQA:	Date:	
Re	esolution:	Disp	osition:	QA: N/C Closed	:	Date:	

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
B		Description of NC		Corrective Action Section B	<del> </del>	Verification	Annroyal	Annroyal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto

NOTE: Date & initial all entries

Date: Thursday, 19/02/2009 1:59:37 PM Usel:: Julie Dawson **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: MOUNTING LUG Job Number: 45915 Part Number: D22303 Job Number: Seq. #: **Description: Machine Or Operation:** 6.0 QC8 SECOND CHECK Comment: SECOND CHECK SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 7.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble and deburr rough edges after tumbling HAND FINISHING RESOURCE 8.0 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 9.0 INSPECT POWDER COAT/CHEMICAL CONVERS Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION POWDER COATING 10.0 M110939 **Comment: POWDER COATING** Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3 START TIME: **OVEN TEMPERATURE:** FINISH TIME: 11.0 QC3 Comment: INSPECT POWDER COATINSPECT POWDER COAT PACKAGING RESOURCE #1 12.0 **PACKAGING 1** Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 13.0 ECTION/W/O RELEASE QC21 Comment: FINAL INSPECTION/W/O RELEASE

Dart Aerospace Lt	a
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	WORK ORDER CH	IANGES				
STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	STEP					STEP PROCEDURE CHANGE By Date Qty Chief Eng /

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
D.4.T.F	0750	Description of NC		Corrective Action Section B		Verification	Ammassal	Annua (a)
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto
							:	

NOTE: Date & initial all entries

Dart Aerospace	Ltd
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W/O:		WORK ORDER CHANGES	-				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
<del>.</del>							
Part No		PAR #: Fault Category: N	CR: Yes	No DQ	۸:	Date:	

NCR:	CR: WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B	·	Verification	A	A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	46915
Description: Mounting Lug	Part Number:	D2230-3
Inspection Dwg: D2230 Rev: F		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

	)	X First Article		Prototype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.450	+/-0.010	4,450				
0.413	+/-0.010	0,417				
0.306	+/-0.010	0.308	/			
3.700	+/-0.010	3.701				
0.750	+/-0.010	0.7415	/			
Ø0.257	+0.005/-0.000	0.257				
0.375	+/-0.010	O.373				
R1.200	+/-0.010	1,200				
0.100 x 45°	+/-0.010	0.90x45°				
		1				

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 09/03/1/	Date: 09/03/13	Date:	

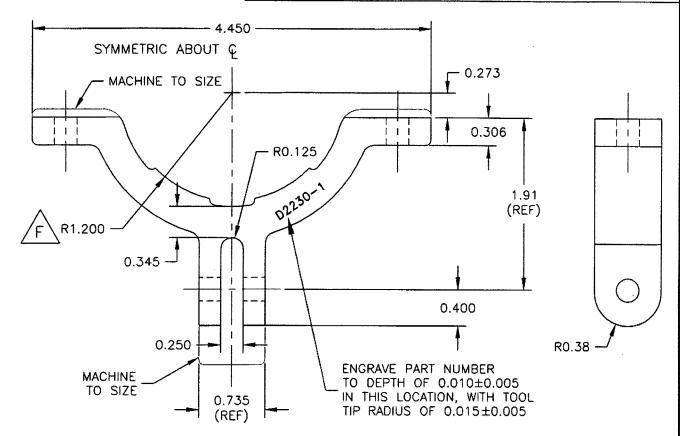
Rev	Date	Change	Revised by	Approved
Α	03.11.11	New Issue	KJ/RF	. 4

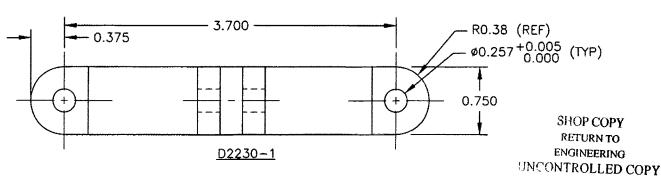


F	ESIG	V	DRAWN BY	5.5= .5= .5=	
1		10	(11)	DART AEROSPAC	CE LTD
L		$\mathcal{A}$	U	HAWKESBURY, ONTARIO.	CANADA
C	HECH	(ED	APPROVED	DRAWING NO.	REV. F
		#	#	D2230	SHEET 1 OF 2
P	ATE			TITLE	SCALE
9	9.1	2.13		MOUNTING LUG	1:1
L	С		94.03.30	RE-DESIGN	
	D		95.01.04	RE-DESIGN	

## RELEASED

DATE		TITLE	SCALE
99.12.13		MOUNTING LUG	1:1
С	94.03.30	RE-DESIGN	
D	95.01.04	RE-DESIGN	
ε	95.01.04	RE-DESIGN	
F	99.12.13	REDESIGN; R1.200 WAS R1.100	





MAKE FROM EXTRUSION D2423 BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

ACID ETCH AND ALODINE PER DART QSI 005 4.1 WORK ORDER POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 NO. HS915

SUBJECT TO AMENDMENT

WITHOUT NOTICE

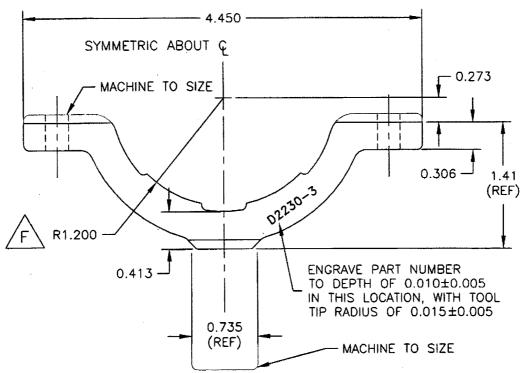
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

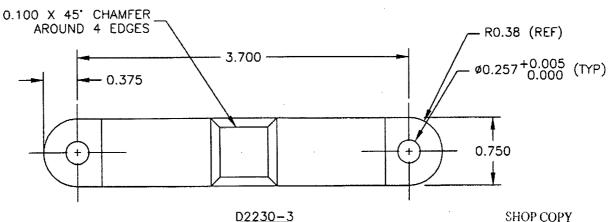




	DESIGN	DRAWN BY	<u> </u>	AEROSPACE LTD sbury, ontario, canada
ı	CHECKED	APPROYED	DRAWING NO.	REV. F
	#	-01	D2230	SHEET 2 OF 2
ı	DATE		TITLE	SCALE
ı	99.12.13		MOUNTING LUG	1:1

## RELEASED





MAKE FROM EXTRUSION D2423 BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4:3.5.1) PER DART QSI 005 4.3 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED SHOP COPY

**RETURN TO** 

**ENGINEERING** 

**UNCONTROLLED COPY** 

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER NO. 4515

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